

Date: Wednesday, 3/8/2006 10:37:57 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHROUD ASSEMBLY
Job Number : 26110	
Estimate Number : 12216	
P.O. Number : N/A	Part Number : D346713
This Issue : 3/8/2006 S.O. No. : N/A	Drawing Number : D3467 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 3/31/2006 Qty: 10 Um: Each
Checked & Approved By : <u>06.03.08</u>	
Comment : est rev. A 06.02.06 new issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



Comment: Sub-Contracting Issue P/O: 00000768 06/03/09
 Email or Ship DXF file to vendor
 Laser Cut per Dwg D3467 flat pattern D3467-13F
 Material release note required

2.0	D346713F	BAFFLE FLAT PATTERN
-----	----------	---------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 DOUBLER FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 1-Deburr

2-Bend as per dwg D3467

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/03/29

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/8/2006 10:37:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHROUD ASSEMBLY

Job Number: 26110

Part Number: D346713

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/03/27

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

06/03/29

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/29

Job Completion



u 06.03.29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

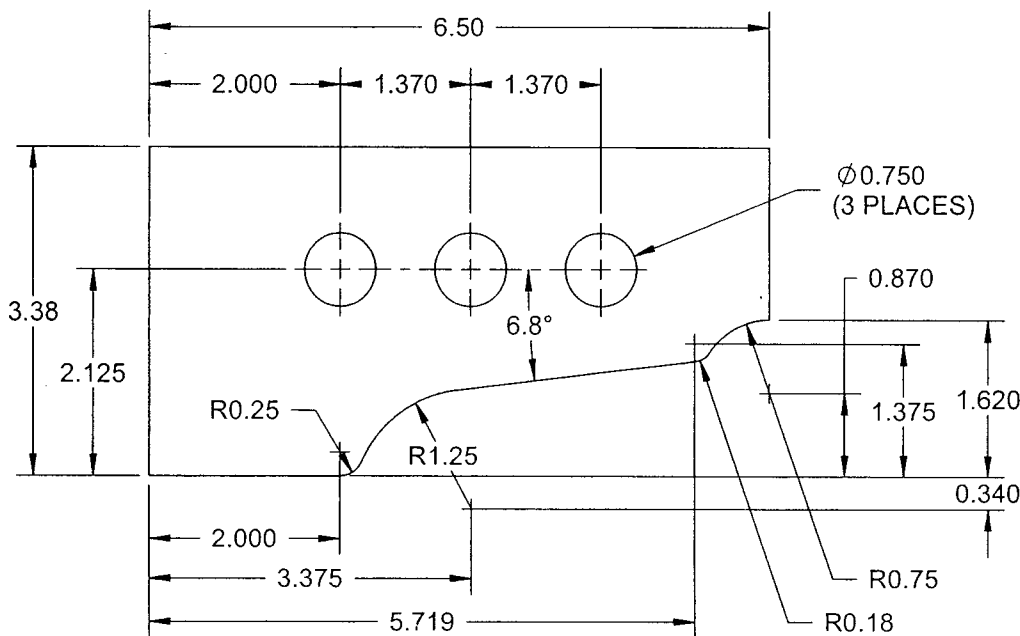
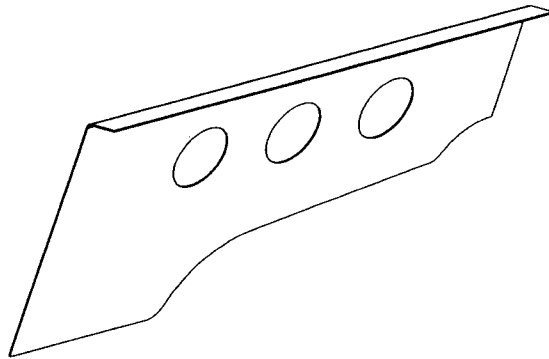
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

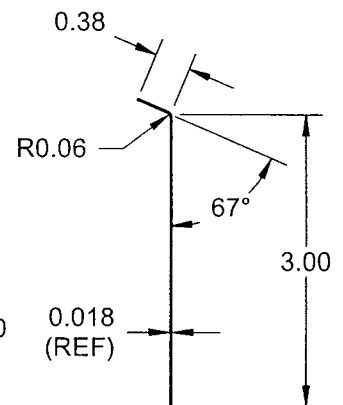
NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3467	REV. A SHEET 12 OF 15
DATE 05.12.07		TITLE SHROUD ASSEMBLY	SCALE 1:2



**D3467-13F BAFFLE
FLAT PATTERN**



**D3467-13 BAFFLE
BEND DETAIL**

NOTES:

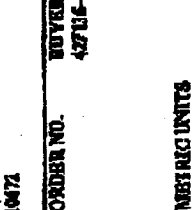
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Kyerson

FROM-INTER 13

T-126 P-007/015 F-587

604-946-4533

		AK Steel Corporation Metallurgical Test Report Coastcon Works Coshocton, OH 43812		Page 1							
INTEGRIS METALS PO BOX 340 MINNEAPOLIS, MN 55440		INTEGRIS METALS 306 1 ST STREET AUBURN, WA 98001		Lead No. 210672 SRN No. 210672							
C U S T O M E R		S H I P P I N G		MILL ORDER NO. 72194-0191 PROCTISOR ORDER NO. 427136-01 BUYER'S ORDER NO. 427136-01							
HEAT 720051		PARENT COIL ID 660019-03		PAINT NO. 74151497							
PIECE 1		NET WEIGHT 3,405 LBS. 402 KG.		PRODUCT - 350000 X COIL							
SK0713143		660019-03		3,405 LBS. 402 KG.							
SK0713144		660019-03		3,405 LBS. 402 KG.							
SK0713145		660019-03		3,405 LBS. 402 KG.							
SK0713146		660019-03		3,405 LBS. 402 KG.							
TOTAL BRIDS 4		TOTAL NET WEIGHT 13,400 LBS. 1605 KG.		3,405 LBS. 402 KG.							
L-Label Analysis of Heat		P-Product Analytical Pursant Cof		CHEMICAL ANALYSIS							
ID	C	MIN	P	S	SI	CR	NI	MO	N	CU	CO
L 720051	.049	2.39	.027	.001	.35	18.18	8.05	.35	.04	.30	.12
SHIPPING DATE: 09/13/05											
REMARKER NO INTENTIONAL ADDITIONS OF MERCURY OR MERCURY COMPOUNDS, RADIUM, ALPHA SOURCE, AND LOW MELTING ALLOYS OR ELEMENTS CAPABLE OF FORMING LOW MELTING ALLOYS WERE MADE THROUGHOUT THE PROCESSING OF THIS MATERIAL.											
PRODUCT DESCRIPTION CR SET TYPE 304 STAINLESS STEEL SLIT EDGE 1/8" THICK 1/2" RADIUS HAVE BEEN SET UNLESS NOTED TO OR NOTED OTHERWISE * A STEEL 240 -04 EX PARA 3.1.1.1 COILS WILL BE DETERMINED BY ASTM E 8 * ASTM A 494 -01 EX PARA 19.1.1.1 COILS WILL BE DETERMINED BY ASTM E 8 EX PARA 26.1.1.1 COIL WILL BE TAGGED ON OUTSIDE ONLY * ASTM A 566 -03 * IN-001 Rev 0, * IN-011 0 * BUYER PART# 78251497 * ASME SA-240 SECTION II PART B (2001 ED, 2002 ADDENDA) EX PARA 3.1.1.1.1 COILS WILL BE DETERMINED BY ASTM E 8 * EX-10204 3.1.1.1											
PARENT COIL ID	FOR (REV)	OR (L, T, D)	COND	SEALING 2 INCH MEASURED	TENSILE STRENGTH (KSI)	Y.S. (KSI)	% OFFSET (KSI)	ROCKWELL HARDNESS	ROCKWELL HARDNESS	PROOF	74
720051					72.2	77.1	77.1	72	74	74	74

Fax Server

T-726 P.008/015 F-537

002/004

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 1
Heat/Lot : 86K8
TIN : B42748

Sold To: INTEGRIS METALS, LTD.
7910 4TH STREET SE
CALGARY, AB T2C2Y2

Ship To: ***CUSTOMER PICKUP***
4375 14TH STREET NORTHEAST
CALGARY
ABT3E7A9

Vendor Information

Cust PO #: 416824

Cust PO DT: 11/03/05

Specifications

STAINLESS STEEL SHEET, COLD ROLLED, ANNEALED AND PICKLED.
ASTMA240/04a 480/04a, 666/03, ASMESA240/04-A05, 480/04-A05, SA666/04
Q08766D-A X 1/8 PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS
CORROSION: ASTM A262/02aE; 180Bend-OK
Buyer Part: 4288441
304 2B .1305 IN 48 IN 96 IN
Country of Origin: UNITED STATES

Mechanical Tests

		UOM	L	O	UOM	L	O
Yield Strength - 0.2% Offset	40	KSI	F	TRANSV			
Tensile Strength (UTS)	93.3	KSI	F	TRANSV			
Rockwell B	85		F	TRANSV			
Pct Uniform Elong 2 In/50mm	57.01	PCT	F	TRANSV			
Rockwell A	85		T	TRANSV			

Chemical Composition

C Carbon-Pct	.059	CR Chromium-Pct	18.360
CU Copper-Pct	.342	MN Manganese-Pct	1.643
MO Molybdenum-Pct	.285	N Nitrogen-Pct	.037
NI Nickel-Pct	8.150	P Phosphorus-Pct	.029
SI Silicon-Pct	.289		

Comments

MATERIAL TEST REPORT

From: NORTH AMERICAN STAINLESS CANADA, IN
740 IMPERIAL ROAD NORTH

Page : 2
Heat/Lot : 86K8
TIN : B42748

Material free from mercury contamination. No weld repairs.
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 Q08763F Cond A
This document certifies the material has been tested in
accordance with applicable specifications described herein
and has met those requirements.

QA by ERIC HESS 02/01/2006

Miscellaneous Data

GUKLPH , ONNE K123
Control #: 90C60214
Part #: 74271441
.135 X .48 X .96

Date: 03/17/06

SOLD TO: INDA LASHA

TO 110880

S/P 90-374786 - 02

[Signature] 3/17/06

The Chemical Analysis and Mechanical Test
data was received via EDI from the above
mentioned vendor.

INTEGRIS METALS, LTD.